

Date: Tuesday, 23/09/2008 10:22:33 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 42233		
Estimate Number	: 12736		
P.O. Number	:	Part Number	: D353515
This Issue	: 23/09/2008 S.O. No. :	Drawing Number	: D3535 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 37810	Material	:
Written By	:	Due Date	: 05/10/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>JUL 08.9.23</u>		
Comment	: Est Rev:A New Issue 07-02-15 JLM		
	: Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1 sf(s)/Unit Total: 13 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 109088 AB 8-10-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: BProg Rev: BAB 8-10-9

(13)

2-Deburr if necessary AB 8-10-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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AB 8-10-9

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S o r t e d (12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-15

EP 08/10/14 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:33 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 42233

Part Number: D353515

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sedolite x12*

7.0

POWDER COATING

POWDER COATING



*M 106 442*



*(13x)*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

*10:30*

OVEN TEMPERATURE:

*320°C*

FINISH TIME:

*11:00*

*M-L 08/10/15*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Fx 08/10/15*

*(13)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*FR/8*

*Fx 08/10/15*

*(13)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/10/15*

Job Completion



*h 08.10.15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 42233
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3535-15
<b>Inspection Dwg:</b> D3535	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.893	X			
2.000	+/-0.010	2.000	X			
5.650	+/-0.010	5.652	X			
9.150	+/-0.010	9.146	X			
14.400	+/-0.010	14.400	X			
19.650	+/-0.010	19.650	X			
24.900	+/-0.010	24.900	X			
30.150	+/-0.010	30.150	X			
33.650	+/-0.010	33.650	X			
35.650	+/-0.010	35.650	X			
39.150	+/-0.010	39.150	X			
Ø0.188	+0.005/-0.001	0.190	X			
24.00	+/-0.030	24.00	X			
16.00	+/-0.030	16.00	X			
8.00	+/-0.030	8.00	X			
5.00	+/-0.030	5.00	X			
0.300	+/-0.010	0.304	X			
0.300	+/-0.010	0.303	X			
0.038	+/-0.010	0.038	X			

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-10-9	<b>Date:</b> 08/10/09	<b>Date:</b>	N/A

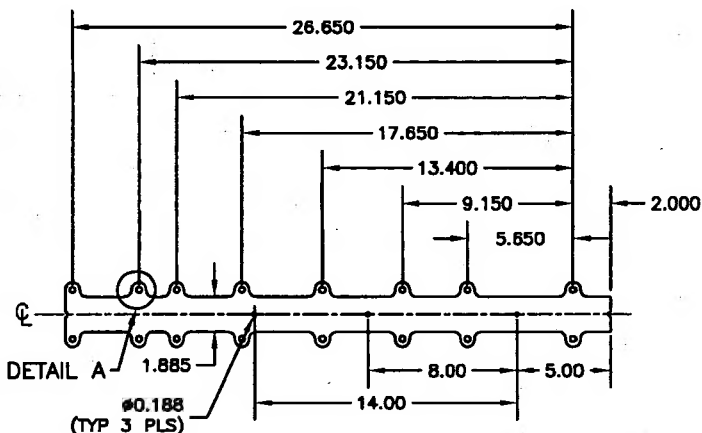
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

**DART**

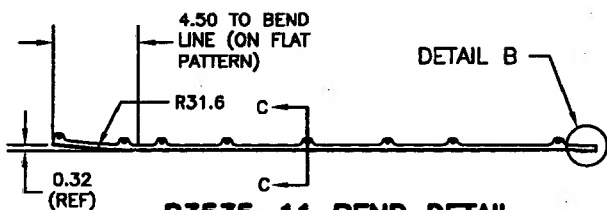
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07.04.24

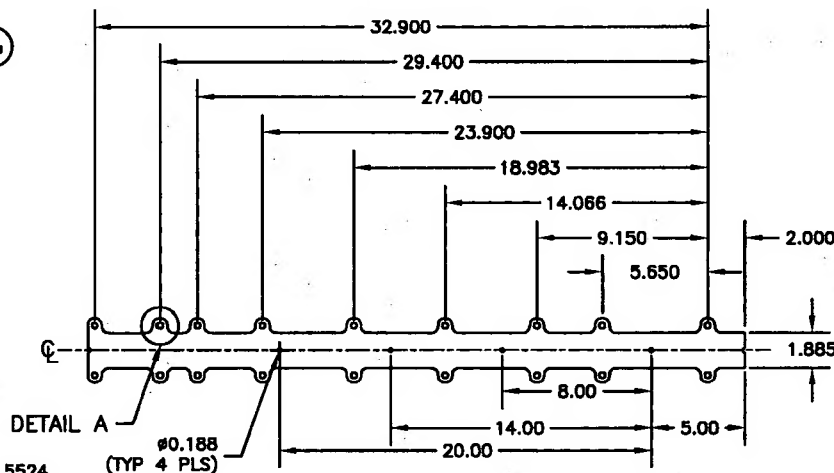
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
<i>[Signature]</i>	<i>[Signature]</i>	D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	



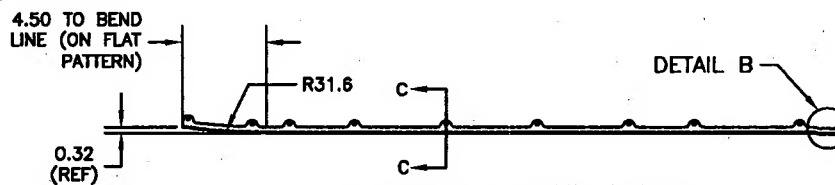
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

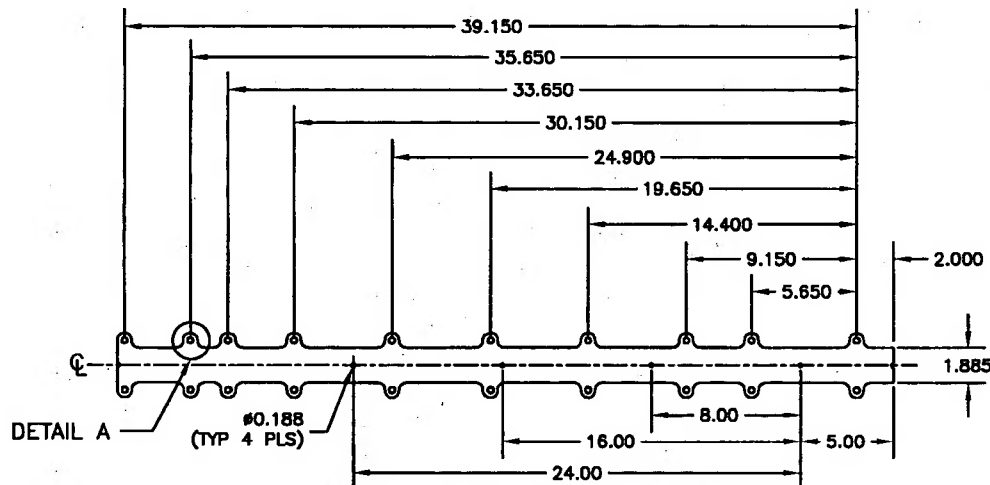
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WITHOUT NOTICE  
WORK ORDER  
NO. 1233

**DART**

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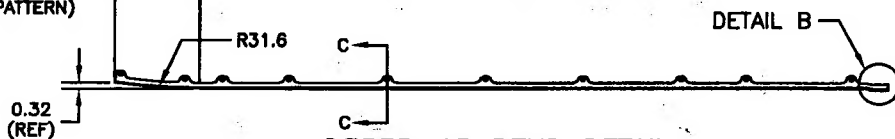
07.04.24

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
		SCALE	1:10	



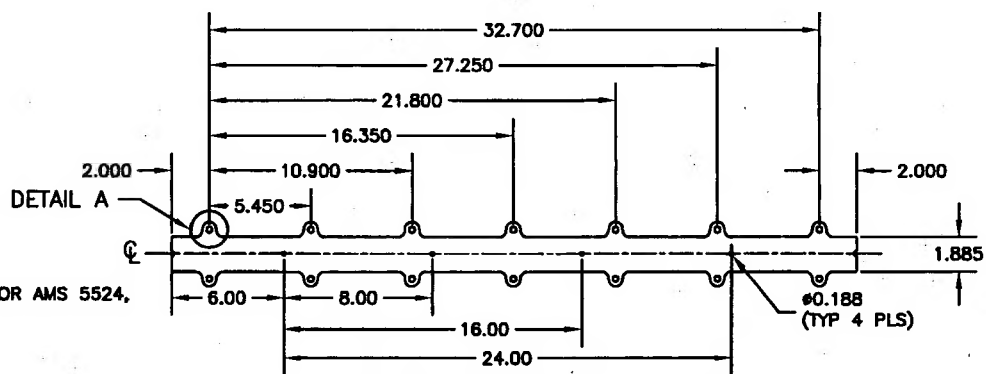
4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**

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NO. 42233



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

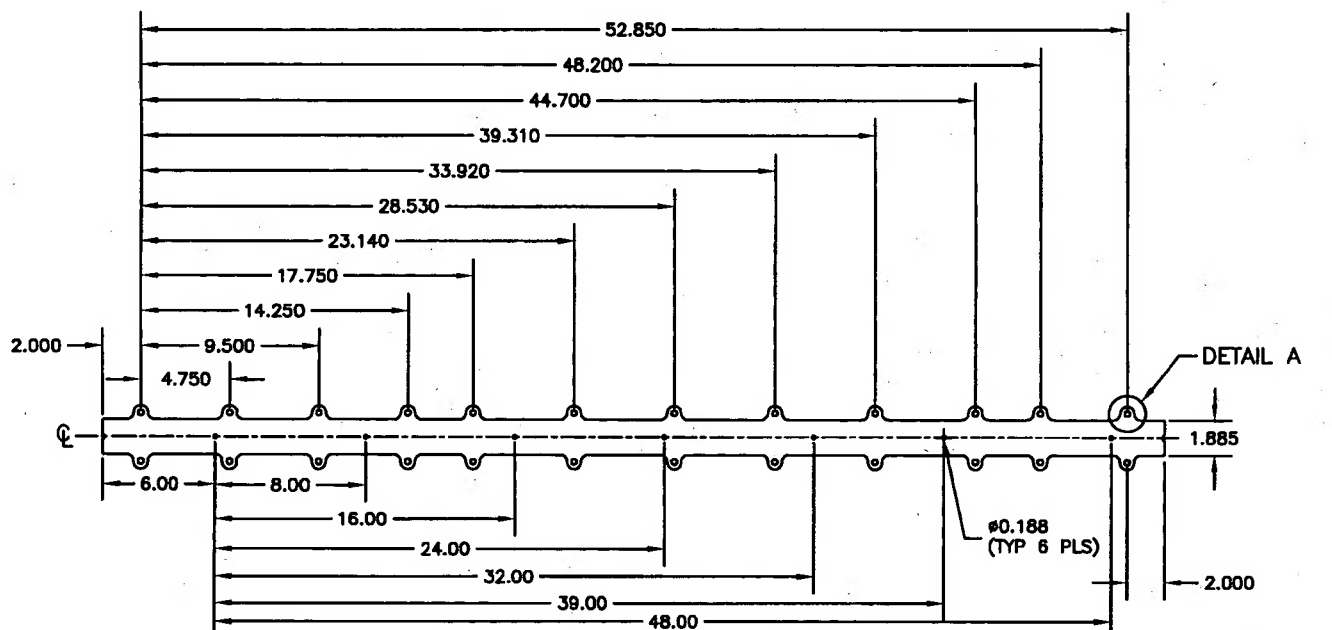
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

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07.04.24



**D3535-23F FLAT PATTERN**

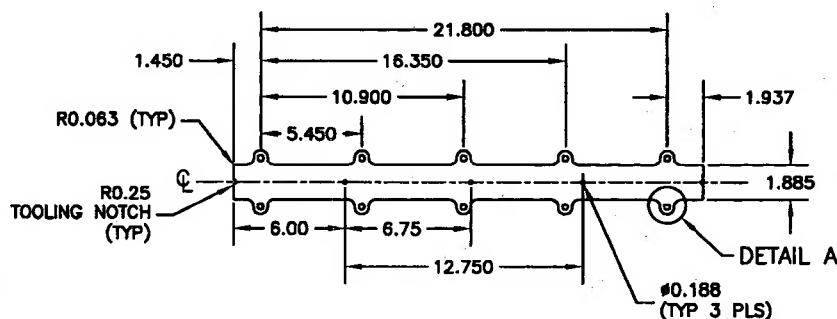


**D3535-23 BEND DETAIL**

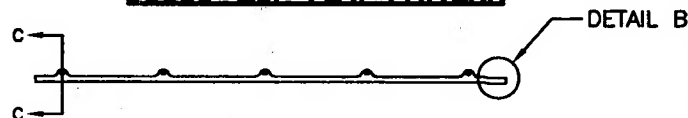
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WORK ORDER  
NO. 4233

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\bar{C}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION



**D3535-25F FLAT PATTERN**



**D3535-25 BEND DETAIL**

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
#	#	D3535
DATE	TITLE	SHEET 3 OF 7
07.04.17	WEARSHOE	SCALE 1:10

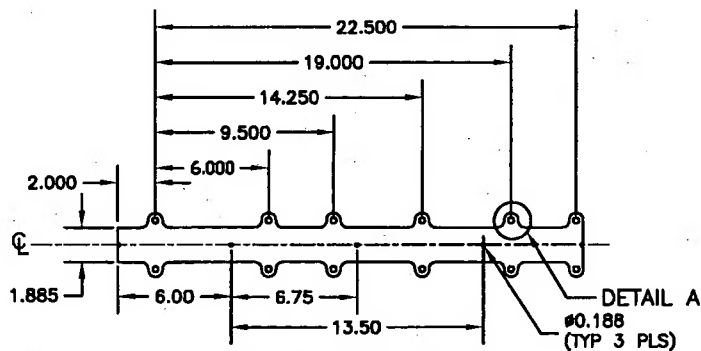


**DART**

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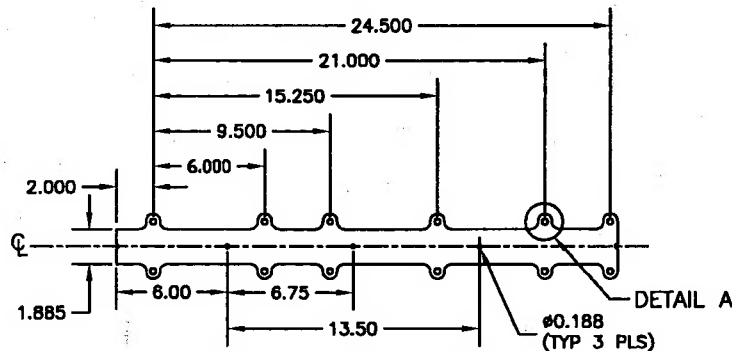
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



**D3535-31F FLAT PATTERN**



**D3535-31 BEND DETAIL**



**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

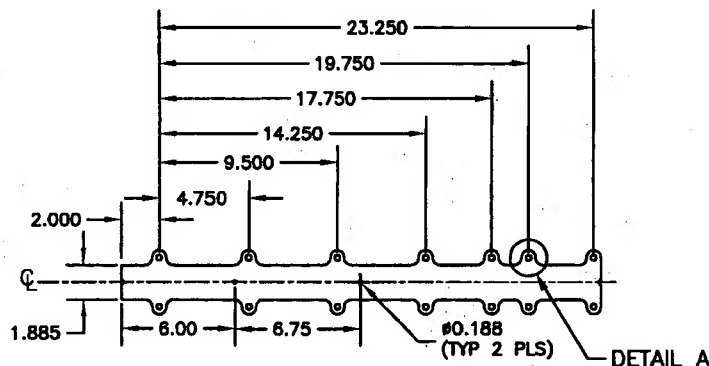
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WORK ORDER  
NO. 422233

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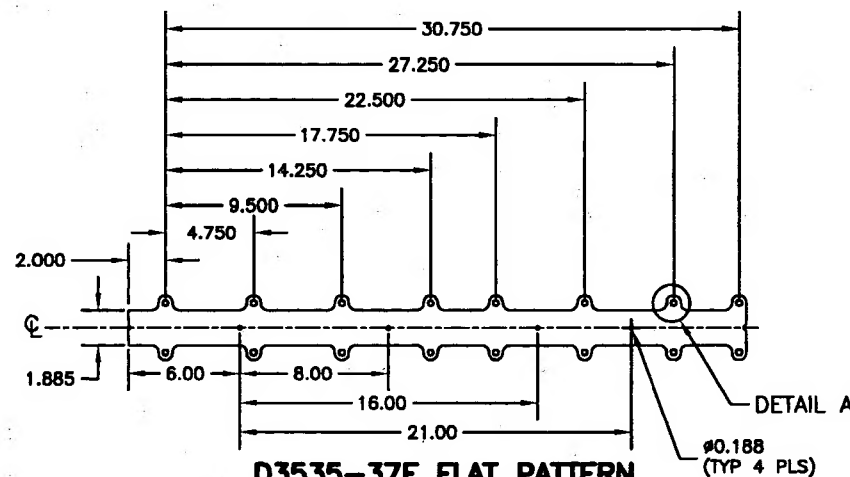
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE		D3535	SHEET 5 OF 7
07.04.17		WEARSHOE	SCALE
			1:10



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

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WORK ORDER  
NO. 112233

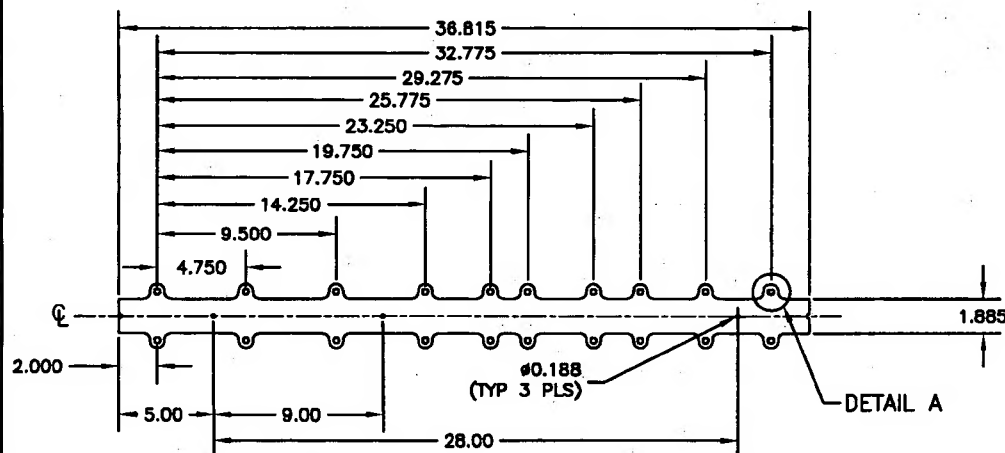
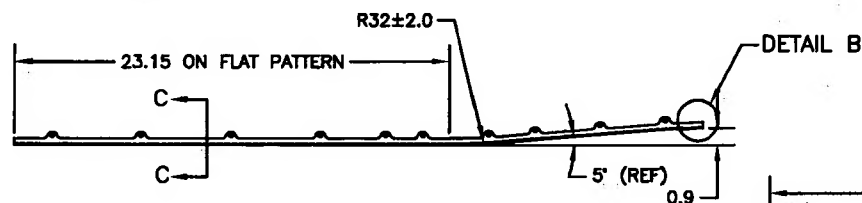
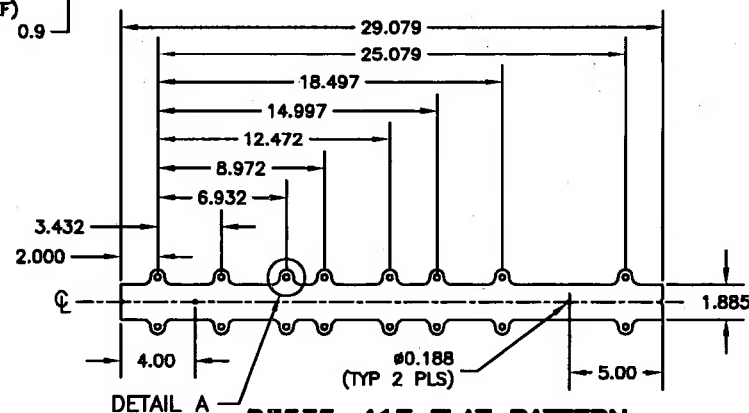
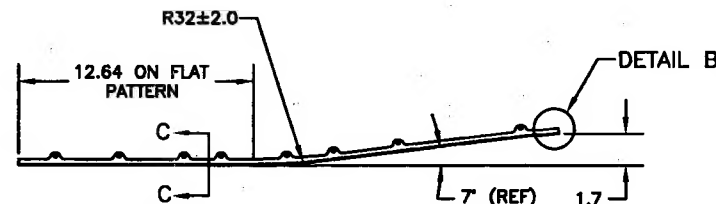
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

RELEASED

07.04.24

**D3535-39F FLAT PATTERN****D3535-39 BEND DETAIL****D3535-41F FLAT PATTERN****D3535-41 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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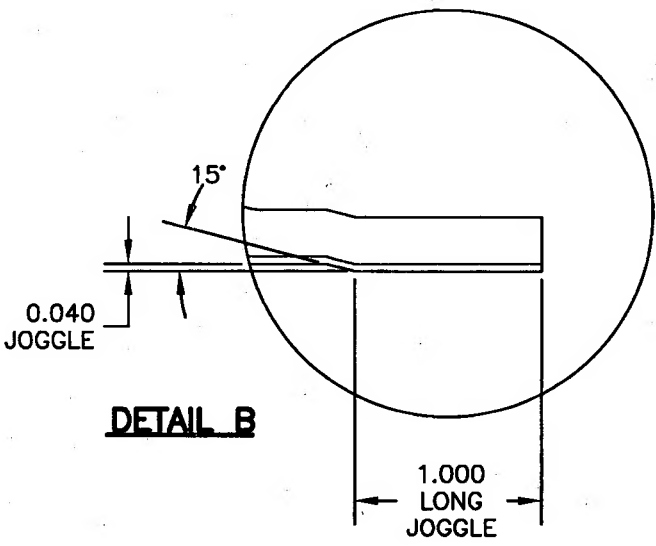
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CB	PH	PORT HADLOCK, WA
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		D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
		SHEET 6 OF 7
		REV. B

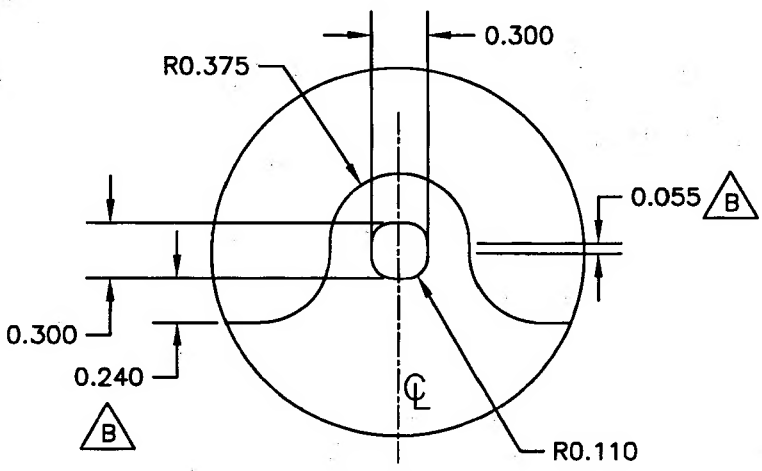


DESIGN	C.B.	DRAWN BY	MH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
				SHEET 7 OF 7
				SCALE 1:1

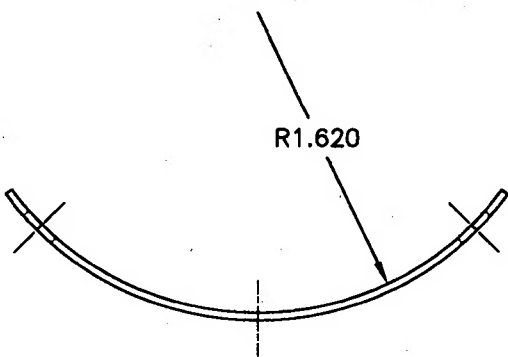
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07.04.24 *[Signature]*



DETAIL B



DETAIL A



SECTION C-C

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WORK ORDER  
NO. 400033